

Date: Monday, 8/21/2006 2:11:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	HANDLE WELDMENT
Job Number	28247			
Estimate Number	10333			
P.O. Number	N/A			
This Issue	8/21/2006	S.O. No. N/A	Part Number	D2530
Prsht Rev.	NC		Drawing Number	D2530 REV B
First Issue	N/A	Type: SMALL /MED FAB	Project Number	N/A
Previous Run	27691		Drawing Revision	B
Written By			Material	N/A
Checked & Approved By		06.08.21	Due Date	9/10/2006
Comment	Est Rev:E	Removed Purchasing 05-11-07	JLM	Qty: 20 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 0.4809 f(s)/Unit Total: 9.6180 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: M101593(09) / M102175(11) → FF 06.09.22 MF. 06/08/29.	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut to length as per Dwg D2536 2-Deburr	<del>FF 06.09.22</del> <del>MF. 06/08/29.</del> <del>FF 06.09.22</del>
3.0	D2534	Lock Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) Pick: QTY 2 Part # D2534 Description Lock Plate Batch B.25406	<del>SB 06/09/20</del>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 2-Deburr	<del>SB 06/09/20</del> <del>FF 06.09.25</del>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes  No  DQA: Date: 06/10/02

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 8/21/2006 2:11:01 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 28247

Part Number: D2530

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/09/25 (20)

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06/09/29 x 20

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/06/09/29 (20)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST183 11/06/09 (20)

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

11/06/09/29 (20)

Job Completion



11/06/09/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

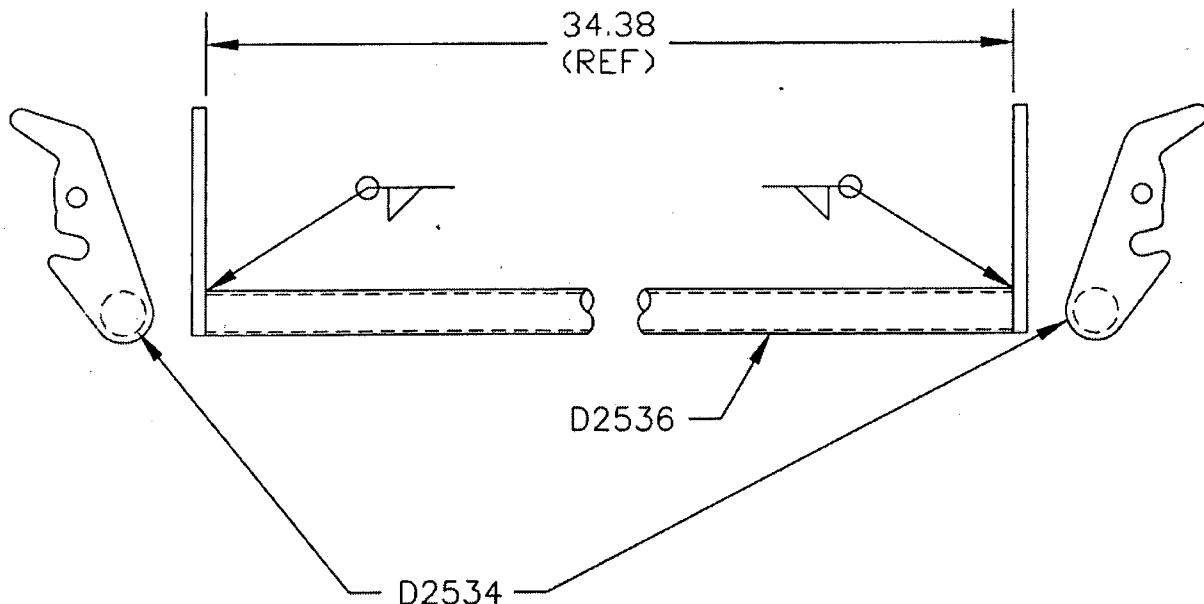
**DART**

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[initials]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *28247*